

Date: Friday, 11/25/2005 11:20:54 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLEVIS
Job Number : 24971	
Estimate Number : 10578	
P.O. Number : <i>N/A</i>	Part Number : D34533
This Issue : 11/25/2005 S.O. No. : <i>N/A</i>	Drawing Number : D3453
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 24735	Material : <i>N/A</i>
Written By : <i>See comment below</i>	Due Date : 12/2/2005
Checked & Approved By : <i>See comment below</i>	Qty: 2 Um: Each
Comment : A 05.09.27 New issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304R1250	Inventory
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Comment: Qty.: *2* 0.2452 f(s)/Unit Total : 0.4904 f(s)

Material: AISI 304 SS Round Bar Ø1.250

(M304R1.250)

Batch: *M16889*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA578 Rev: *—* & Dwg D3453 Rev: *A* *Manual*

2- Deburr as per dwg D3453

BG 05.11.25 2

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BG 05.11.25 2

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Mill as per Folio FA578 Rev: *AA* & Dwg D3453 Rev: *A*

2- Deburr as per dwg 3453

BG 05.11.25 2

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BG 05.11.25

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Job Number:



Seq. #: Machine Or Operation: Description :

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- Drill as per dwg D3453

2-Deburr as per dwg D3453

BG 05-11-25

2

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BG 05-11-25

2

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S.G. 05/11/25 2

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 425

C205111282

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

18 05/11/29

Job Completion



[illegible]

Measured by:	
Date:	

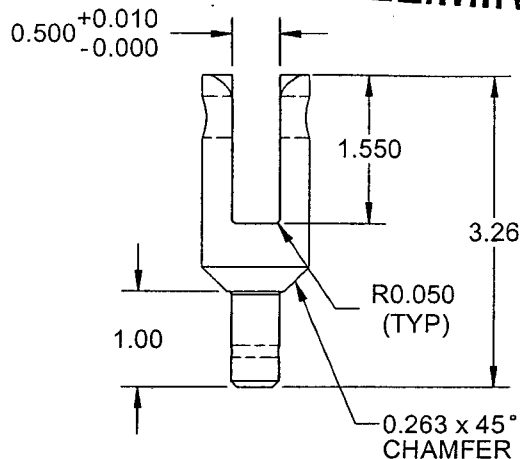
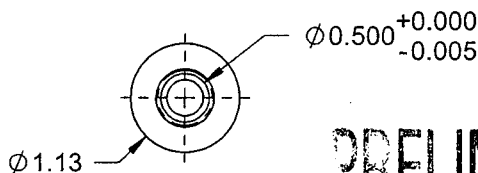
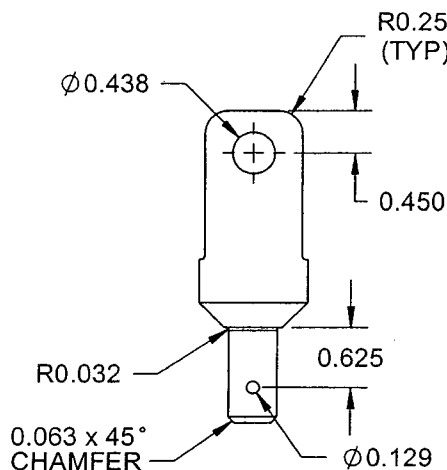
Audited by:	
Date:	

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

PRELIMINARY ISSUE

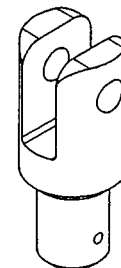
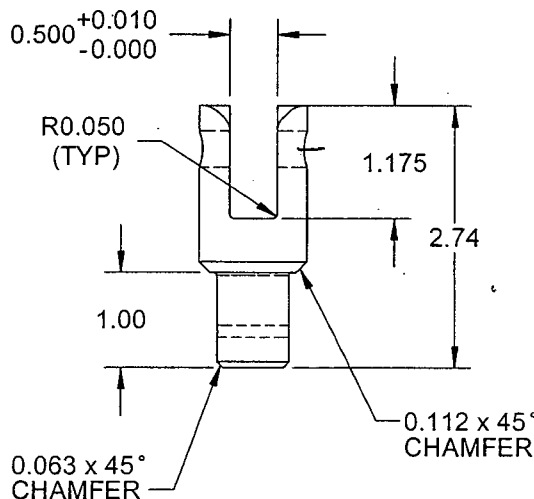
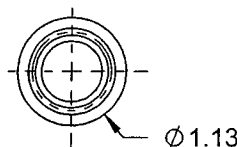
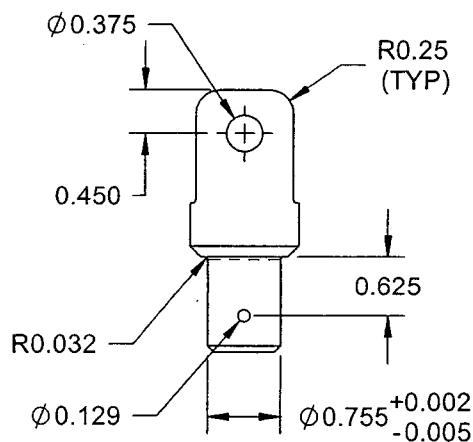
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3453	REV. A SHEET 1 OF 2
DATE 05.09.02	TITLE CLEVIS		SCALE 1:2
A	05.09.02	NEW ISSUE	



D3453-1 CLEVIS

PRELIMINARY ISSUE

REFERENCE ONLY



11/6889

D3453-3 CLEVIS

PRELIMINARY ISSUE

PRELIMINARY ISSUE

NOTES

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH P/N USING FINE POINT PERMANENT MARKER
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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